

D3594-5

Work Order ID 116732 B116732

116732

Page 1

May-23-14 11:39:53 AM

Item ID: D3594-5

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Doubler

Start Date: 4/23/14 Start Qty: 24.00

24

Cust Item ID:

Required Date: 4/23/14 Req'd Qty: 24.00

24

Customer:

Reference:

Run Start *NR1*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3594

Rev B

105

0.00

105

Purchasing

Purchasing

Memo

ISSUE PO 24388

1-Cut as per Dwg D3594

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

0.00

CL 14/05/28 24

115

Receive & Inspect for Damage & Mat'l Certs

0.00

115

Packaging

Packaging

Memo

0.00

Prylapp 8 (24)

Work Order ID 116732

116732

Page 2

May-23-14 11:39:53 AM

Item ID: D3594-5 Accept *N9000040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Doubler
Start Date: 4/23/14 Start Qty: 24.00 *24* Cust Item ID:
Required Date: 4/23/14 Req'd Qty: 24.00 *24* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125 *125* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00 14/6/20				24			
130 *130* Small Fab Small Fab Small Fab	Small Fab Memo 1-C'SINK AS PER dwg d3594	0.00 0.00				24			14/6/23 DAS 36 89
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00 14/6/23				24			14/6/23 DAS 36 89

May-23-14 11:39:53 AM

Page 3

Accept

Setup Start *NS1*

Stop *NS2*

Start Date: 4/23/14 **Start Qty:** 24.00 ***24***

Cust Item ID:

Required Date: 4/23/14 **Req'd Qty:** 24.00 ***24***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150 Chemical Conversion Coat per QSI005 4.1

0.00

150

0.00

HandFinish

Memo

Hand Finishing

QB
14/6/23

160

Qc7

~~QC3-~~ Inspect Part Finish

0.00

DAS
27
9-89

160

0.00

OC

Memo

Quality Control

170

Identify as per dwg & Stock Location: ST050 0.00

0.00

170

0.00

Packaging

Memo

Packaging

Work Order ID 116732

May-23-14 11:39:53 AM

116732

Page 4

Item ID: D3594-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Doubler

Stop ***NS2***

Start Date: 4/23/14 Start Qty: 24.00

24

Cust Item ID:

Required Date: 4/23/14 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

MLJ 14-06-24

MLJ 14-06-24

Picklist Print

May-23-14 11:39:52 AM

Page 1

Work Order ID: 116732

116732

Parent Item: D3594-5

D3594-5

Parent Item Name: Doubler

Start Date: 4/23/14

Required Date: 4/23/14

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP Rev :A New Issue 08.07.07 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.080

Purchased

No

100

sf

382.5600

0.055

2

M6061T6S 080

**

C214/06/10

6061-T6 .080 Sheet

m129439

Location

Loc Qty

Loc Code

MAT021

382.56

m126309

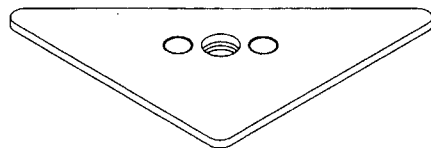
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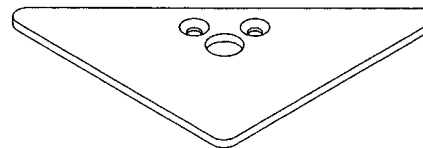
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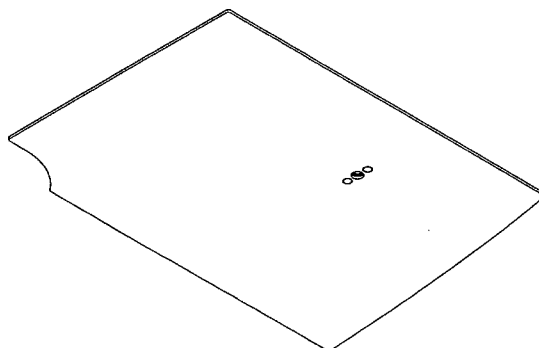
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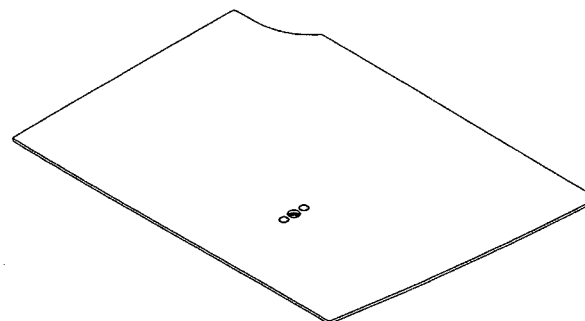
D3594-041 DOOR DOUBLER ASSEMBLY



D3594-5 DOOR DOUBLER



D3594-043 FLOOR DOUBLER ASSEMBLY



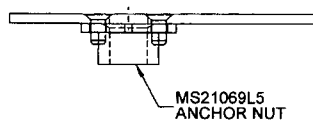
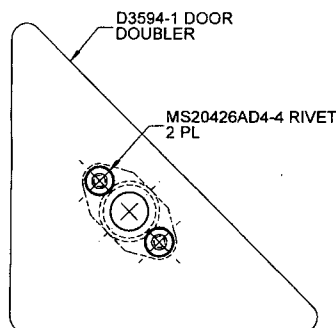
D3594-044 FLOOR DOUBLER ASSEMBLY

116732 MJS
140424

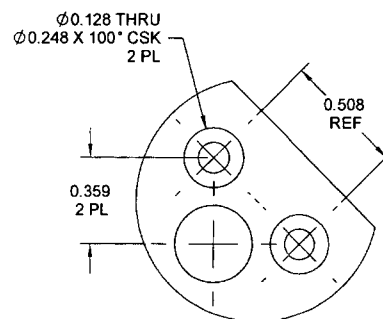
RELEASED
080226

B	REFORMAT TO B SIZE DRAWING. SHEET 2 ADD -5.	AJS	08.05.14
A	NEW ISSUE	MB	07.04.13
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3594 TITLE DOUBLER SCALE NTS	
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		REV. B SHEET 1 OF 4	
DATE	08.05.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

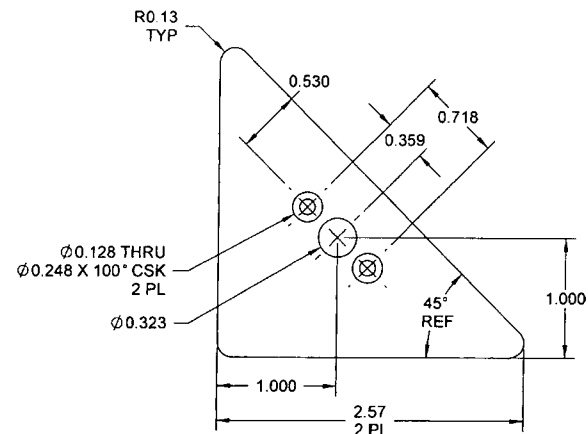
QTY. -041	PART NUMBER	DESCRIPTION
X	D3594-041	DOOR DOUBLER ASSEMBLY
1	D3594-1	DOOR DOUBLER
1	MS21069L5	ANCHOR NUT
2	MS20426AD4-4	RIVET, CSK



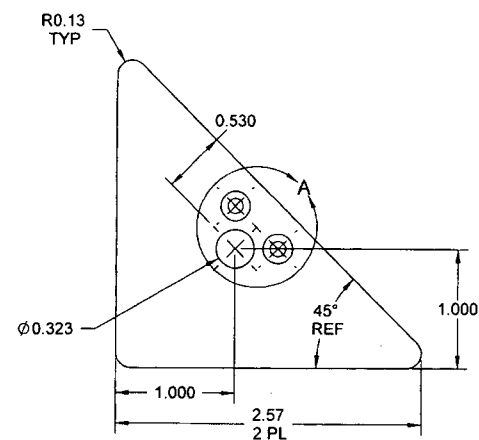
4 D3594-041 DOOR DOUBLER ASSEMBLY



DETAIL A
SCALE 2X



D3594-1 DOOR DOUBLER







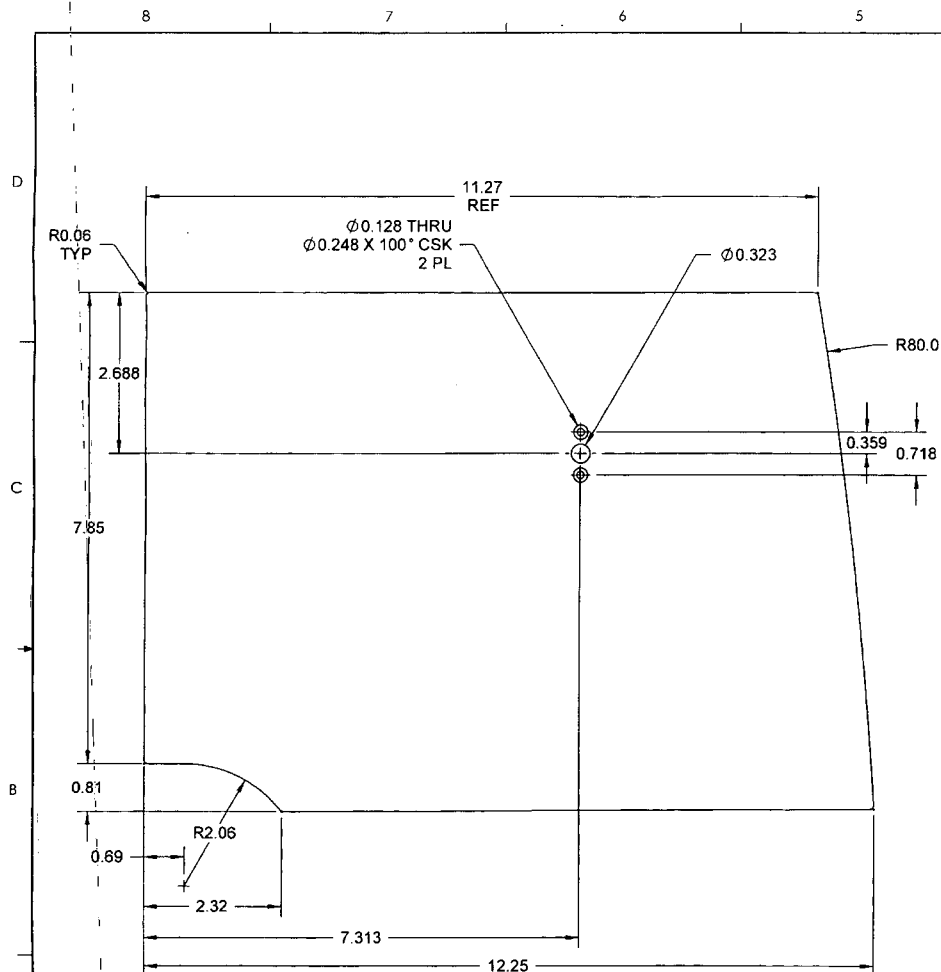
5 D3594-5 DOOR DOUBLER

RELEASED
08 06 26 11

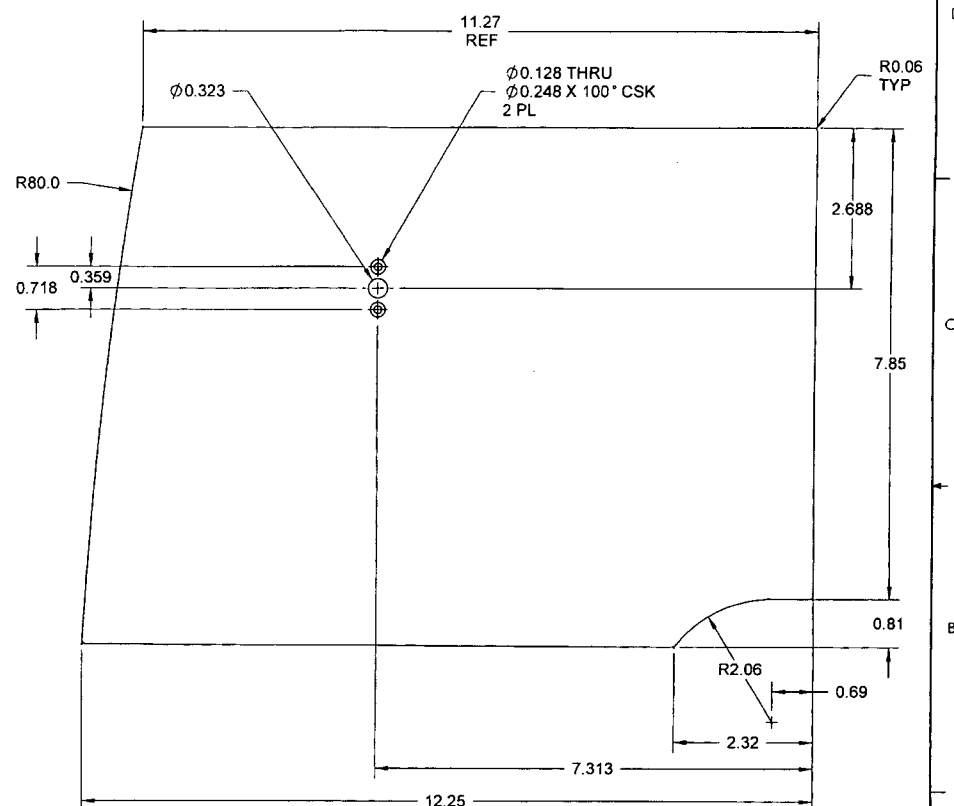
NOTES:

- 1) MATERIAL: -1 & -5
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-041" USING FINE POINT PERMANENT INK MARKER
- 5) IDENTIFY WITH DART P/N "D3594-5" USING FINE POINT PERMANENT INK MARKER
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WEIGHT -041: 0.04 lbs
-5: 0.03 lbs

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3594	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
DATE	08.05.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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D3594-3 FLOOR DOUBLER



D3594-4 FLOOR DOUBLER

RELEASED
08.05.14

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3594	REV. B
MFG. APPR.	<i>[Signature]</i>	TITLE	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	DOOR DOUBLER ASSEMBLY	SCALE NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO24388**

Purchase Order Date 5/28/2014

PO Print Date 6/10/2014

Page Number 4 of 5

Order From :

VC-TPI001

Ship To :

DART AEROSPACE LTD

TPI INDUSTRIES INC.
148 RUE GOODFELLOW
DELSON, QUEBEC J5B 1V4
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

450-633-0484

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

10	116732	D3594-5 DOUBLER	6/20/2014	24.00	\$1.60	\$38.40
			Yes			
			6/20/2014			

CUT AS PER DWG D3594

Line Total: \$38.40

11	71401-45	PROCUREMENT QUALITY CLAUSES	6/20/2014	1.00	\$0.00	\$0.00
			No			
			6/20/2014			

Quality Procurement Clauses
A005 RIGHT OF ENTRY
A016 PERSONNEL QUALIFICATION
A042 DART NOTIFICATION BY SUPPLIER

Line Total: \$0.00

12	71425-20	EXTRA CHARGE TO CUT AT 10 FT	6/20/2014	1.00	\$60.00	\$60.00
			Yes	Each		
			6/20/2014			

Line Total: \$60.00

Note:

6/10/2014

T.P.I. INDUSTRIES INC.**Packing Slip**

148 GOODFELLOW
DELSON, QUÉBEC J5B 1V4
CANADA
Tel: (450) 633-0484
Fax: (450) 633-0879

Packing Slip No.: 6152
Date: 2014-06-17
Page: 1

Sold to:	Ship to:
Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada	Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada
Order No.: 24388	Sold By: JONATHAN LESSARD
Shipped By:	Ship Date: 2014-06-18
Tracking No.:	

Item No.	Unit	Description	Quantity
d2278	Chaque	d2278 step leg	50
d3065-5	Chaque	d3065-5 step leg	80
d3594-4	Chaque	d3594-4 floor doubler	20
d3594-3	Chaque	d3594-3 floor doubler	20
d3208-7	Chaque	d3208-7 filler	20
d2935	Chaque	d2935 saddle spacer	40
d3066-1	Chaque	d3066-1 spacer	80
d3065-5	Chaque	d3065-5 step leg	80
d3578-1	Chaque	d3578-1 doubler	40
d3594-5	Chaque	d3594-5 doubler	24

Comment: Net / 30 from date of invoice 2% svc. chg. on invoices over 30 days